

Work Order ID 78130

78130

Page 1

December-29-11 10:32:54 AM

Item ID: D3806-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 29/12/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/12/29 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw.Nbr	Revision Nbr								
D3806	B								

100 0.00

100

Cold Saw 0.00 F.K. 12/01/22 50 ϕ

Hyd Mech

Memo

Cut blanks at 44.50"

FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

110

0.00

110

HAAS I 0.00

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB070 & dwg

FOLIO REV: 44

DWG REV: B

2-Deburr as required

af/rt 12-01-23 (450)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78130

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N900040100

Setup Start *NS1*

Stop *NS2*

50

Cust Item ID:

50

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

FOR CLAMPING PURPOSE WHEN WELDING 1.00" WAS ADDED ON LENGTH AND IT WILL BE CUT TO LENGTH AFTER WELDING

0.00

130

QC

Memo

0.00

Quality Control

Weld per dwg A/R Hardcoat S.S. Batch: 0.00

133

Large Fab

Memo

~~0.00~~

Large Fab

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#:

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 29/12/2011 Start Qty: 50.00

50

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

136

QC10- Inspect visual per QSI004- ground welds

0.00

136

QC

Memo

0.00

Quality Control

137

QC5- Inspect part completeness to step on W/O

0.00

137

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: W/A

0.00

140

Packaging

Memo

0.00

Packaging

A 127-31 155

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/2/11

R 12-01-31
(50)

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Picklist Print

December-29-11 10:32:58 AM

Page 1

Work Order ID: 78130

78130

Parent Item: D3806-5

D3806-5

Parent Item Name: Bar

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC IPP Rev:D
 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	44.9970	3.666	192.9474			

M304B0 500X2 500

304 BAR .500 x 2.50

Location	Loc Qty	Loc Code
MAT050	44.997	
112764	8.312	
116135	0.375	
117685	4.4	
119231	31.91	

In 304 B0.250 x 0.500

← 119872 →

192.948 FK 12/01/22.

could not issue mat'l

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8

7

6

5

4

3

2

1

D3806-1 BAR

D3806-5 BAR

D3806-3 BAR

D3806-7 BAR

RELEASED
2011-10-03

SHOP COPY
 RECEIVED
 BY [signature]
 UNCONTROLLED COPY
 SUBJECT TO INCIDENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 78130 M.L.J
 11/12/29

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PART11-105	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	DART AEROSPACE USA, INC.	
DRAWN	gp	KENT, WA	
CHECKED	gp	DRAWING NO.	REV. B
MFG. APPR.	[signature]	D3806	SHEET 1 OF 3
APPROVED	[signature]	TITLE	SCALE
DE APPR.	[signature]	BAR	NTS
DATE	11.09.29	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONTROLLED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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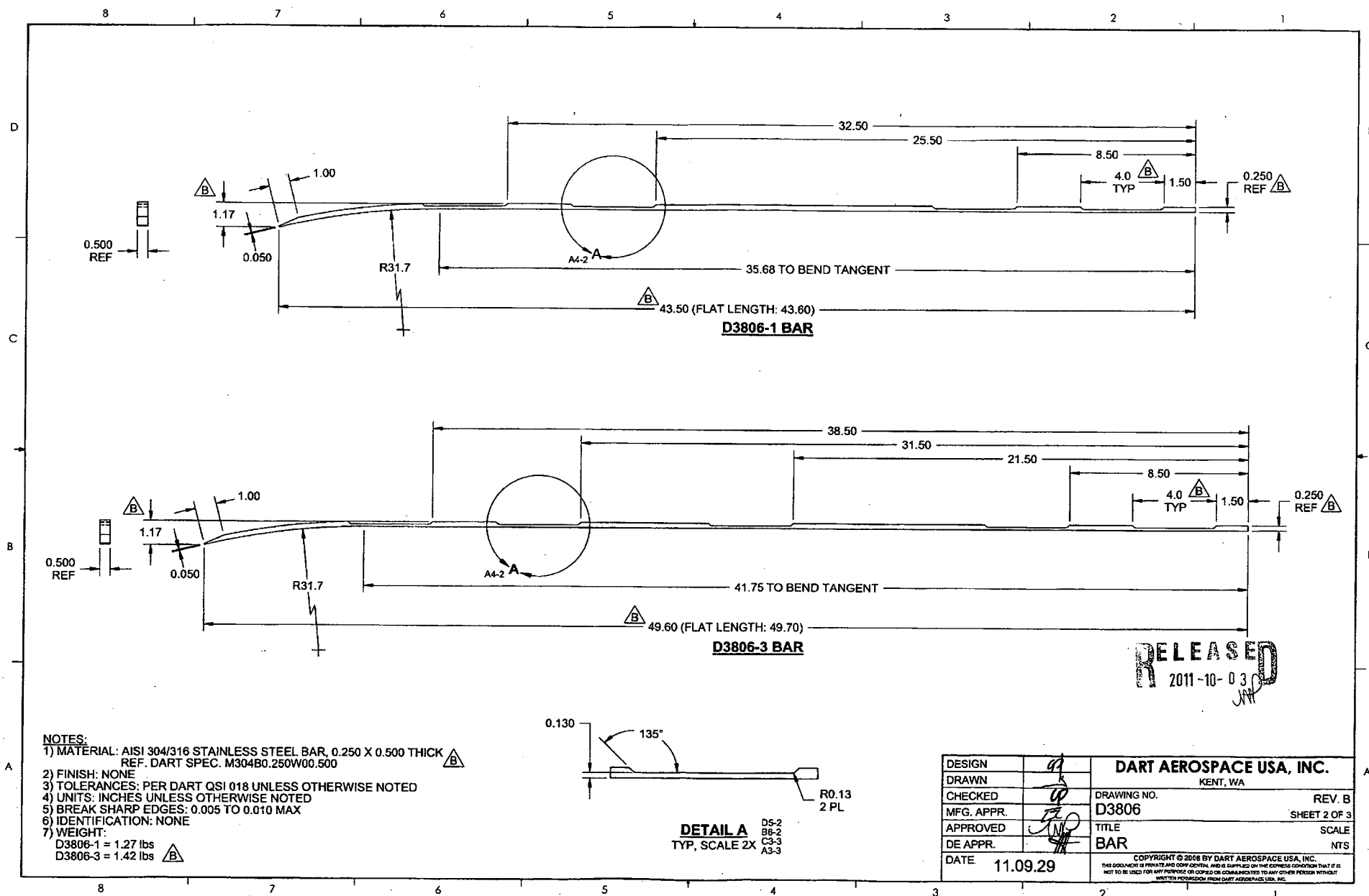
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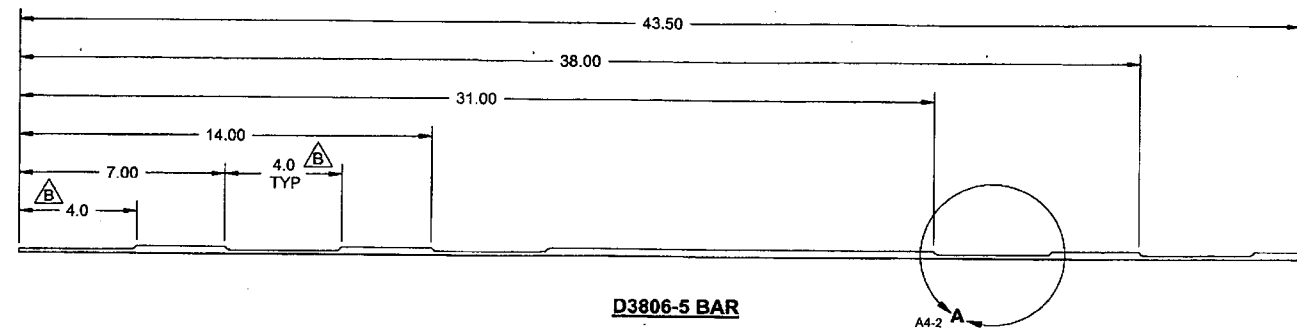
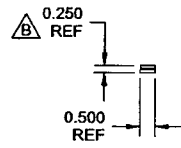
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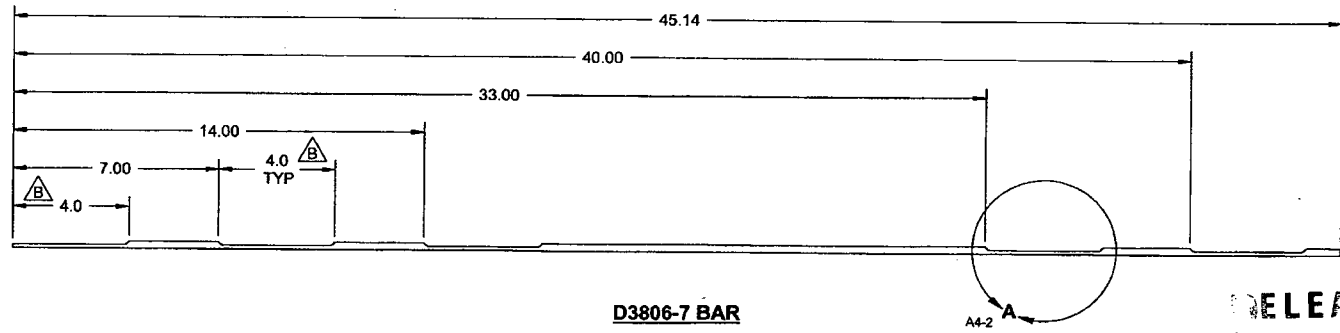
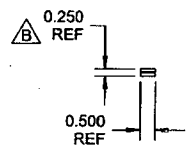
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D3806-5 BAR



D3806-7 BAR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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